

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : ANGLE

Job Number : 48301

Estimate Number : 13959

P.O. Number :

Part Number : D38971

This Issue : 01/06/2009 S.O. No. :

Drawing Number : D3897 PREL

Prsht Rev. : NC

Project Number : N/A

First Issue : 1/1 Type : SMALL / MED FAB

Drawing Revision : PREL

Previous Run :

Material :

Written By :

Due Date : 01/06/2009

Qty: *split*
2 MF
8 Um: EachChecked & Approved By : *MF 09-01-06*

Comment : Est Rev:A 09-06-01 new issue EC verified by:DD

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6S050

6061-T6 .050 Sheet



Comment: Qty.: 0.2541 sf(s)/Unit Total : 1.5246 sf(s)

M6061-T6 sheet 0.050"

batch: *110791**RB 9-6-1*

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg

Dwg Rev: *PRF*Prog Rev: *Lim**RB 9-6-6*

2- Deburr if necessary

RB 9-6-1

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RB 9-6-1

4.0

QC8

SECOND CHECK

ENGINEERING
APPROVAL

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg

*SB 09/06/01**(2)*

Date: Monday, 01/06/2009 10:31:43 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 48301

Part Number: D38971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ump

09/06/01

(12)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2

09/06/01

(2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

MP 09/06/01

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker, then Stock

Location: _____

9/6/01 SL

David

Eagle Coptus

09-06-01

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01

JA

Job Completion



POSITIVE RECALL

EFFECTIVE 09/06/01 AUTH W

RELEASED MP DATE 09/06/01

DART AEROSPACE LTD		Work Order: 48301
Description: ANGLE		Part Number: D3897-1
Inspection Dwg: D3897-1	Rev: PRE L	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

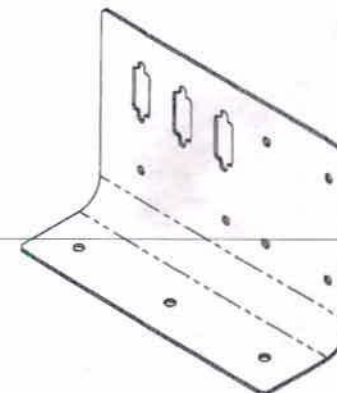
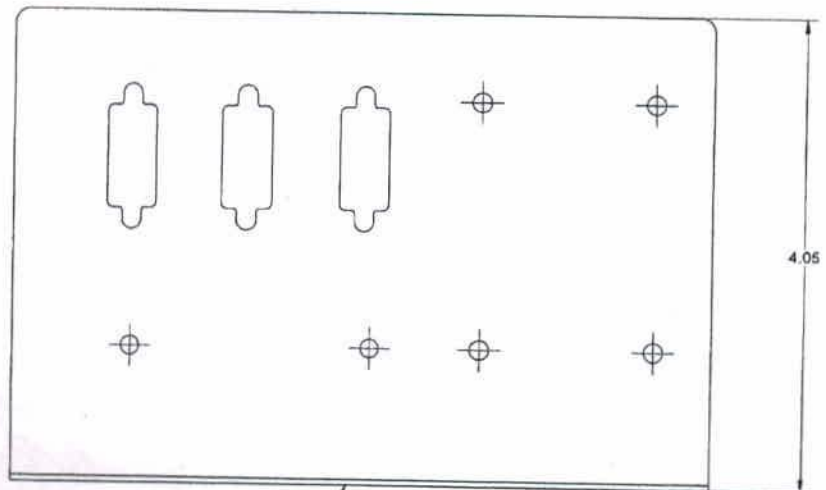
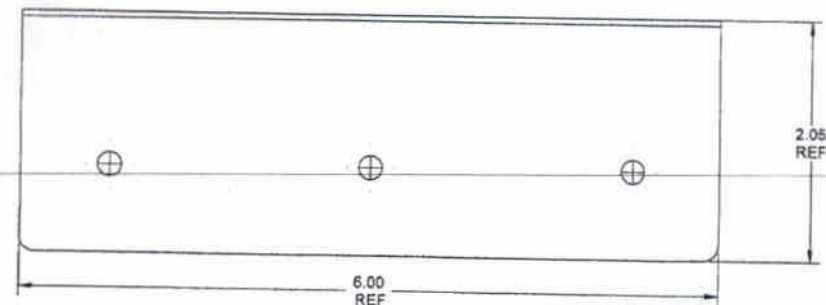
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .159	+ .005 - .001	.161	X			
Ø .204	+ .005 - .001	.206	X			
.50	± .030	.500	X			
1.500	± .010	1.499	X			
3.00	± .030	3.003	X			
4.00	± .030	4.002	X			
5.00	± .030	5.001	X			
6.00	± .030	6.001	X			
.75	± .030	.750	X			
2.88	± .030	2.870	X			
3.41	± .030					
5.07	± .030	5.074	X			
5.82	± .030	5.833	X			
.75	± .030	.751	X			
3.00	± .030	3.005	X			
5.25	± .030	5.257	X			
2.060	± .010	2.061	X			
.71	± .030	.710	X			
1.239	± .010	1.244	X			
1.425	± .010	1.426	X			
.880	± .010	.889	X			
.050	± .010	.046	X			

Measured by: JB
Date: 9-6-1

Audited by: [Signature]
Date: 09/06/01

Prototype Approval: N/A
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**PRELIMINARY
ISSUE**

MD 01/06/01

D3897-1 ANGLE
MADE FROM D3897-1F

NOTES:

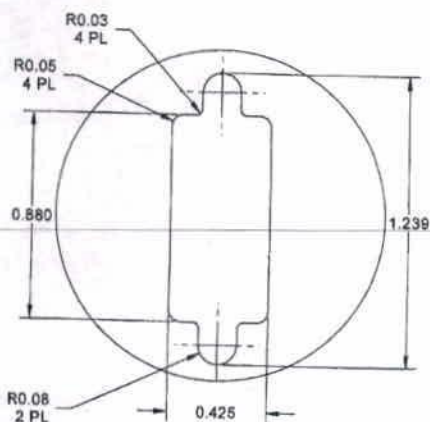
- 1) MATERIAL: MADE FROM D3897-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3897-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.03.30			

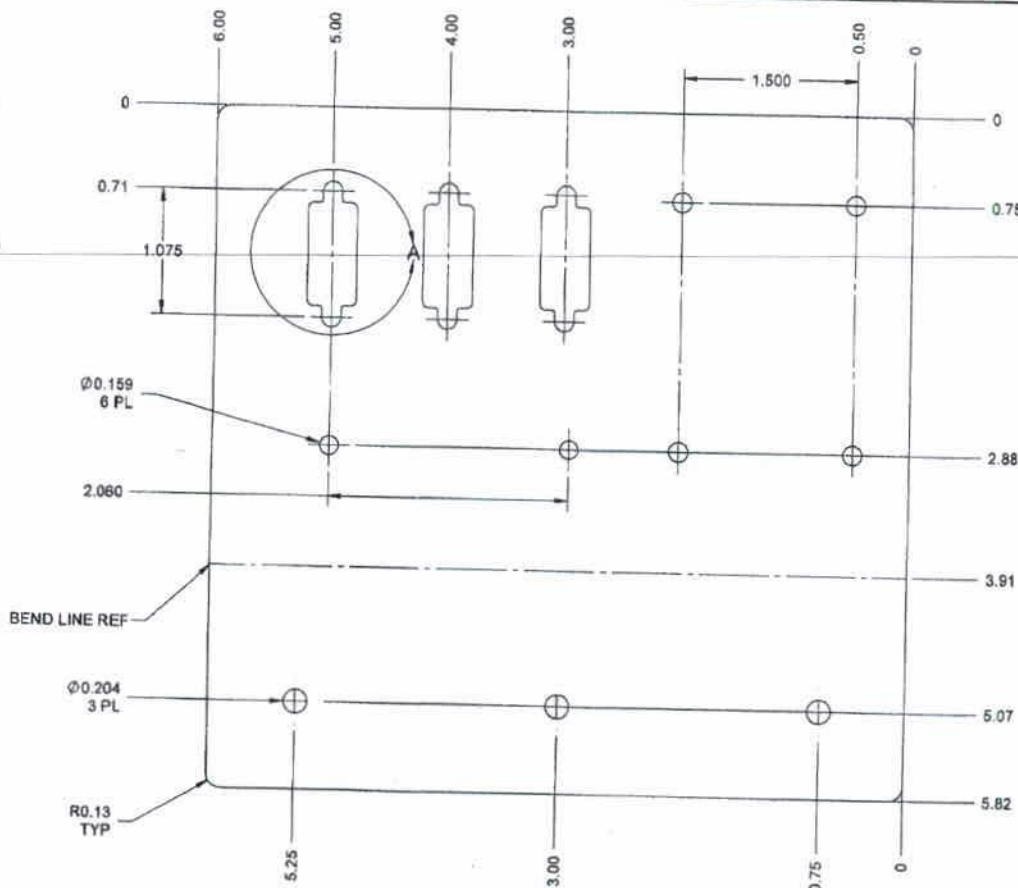
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3897	REV. A
TITLE ANGLE	SHEET 1 OF 2
SCALE NTS	

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103845301



DETAIL A D5
TYP
SCALE 2X



D3897-1F ANGLE FLAT PATTERN

NOTES:

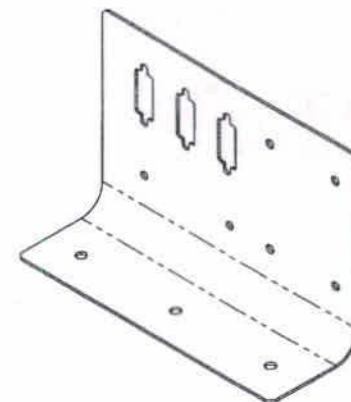
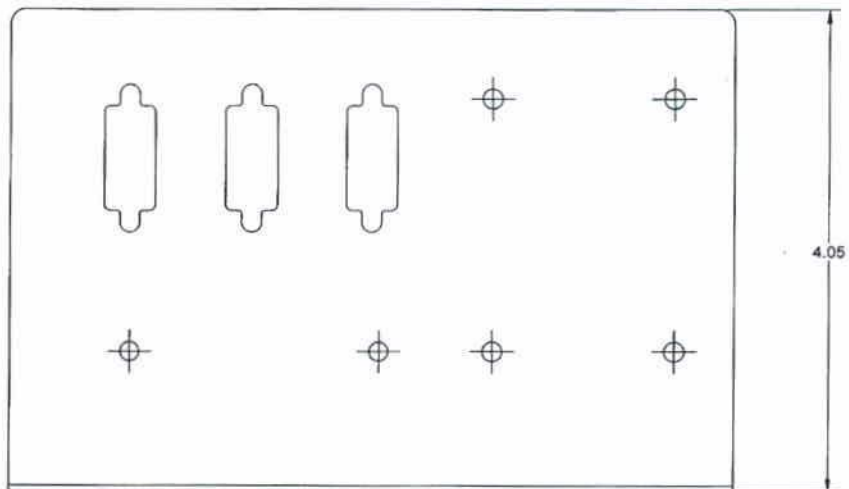
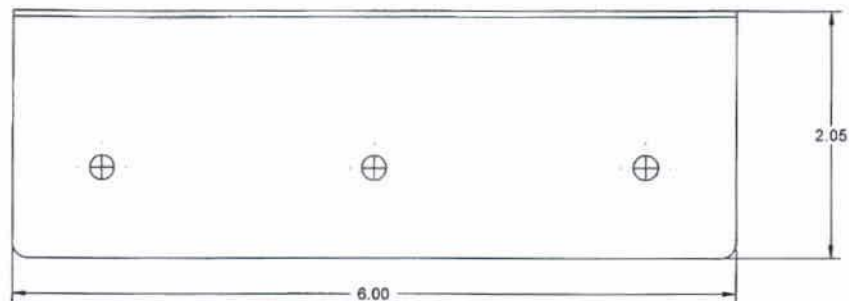
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

**PRELIMINARY
ISSUE**

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV.
MFG. APPR.		D3897	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ANGLE	NTS
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W/0 48301

W/0 04/06/01



D3897-1 ANGLE
MADE FROM D3897-1F

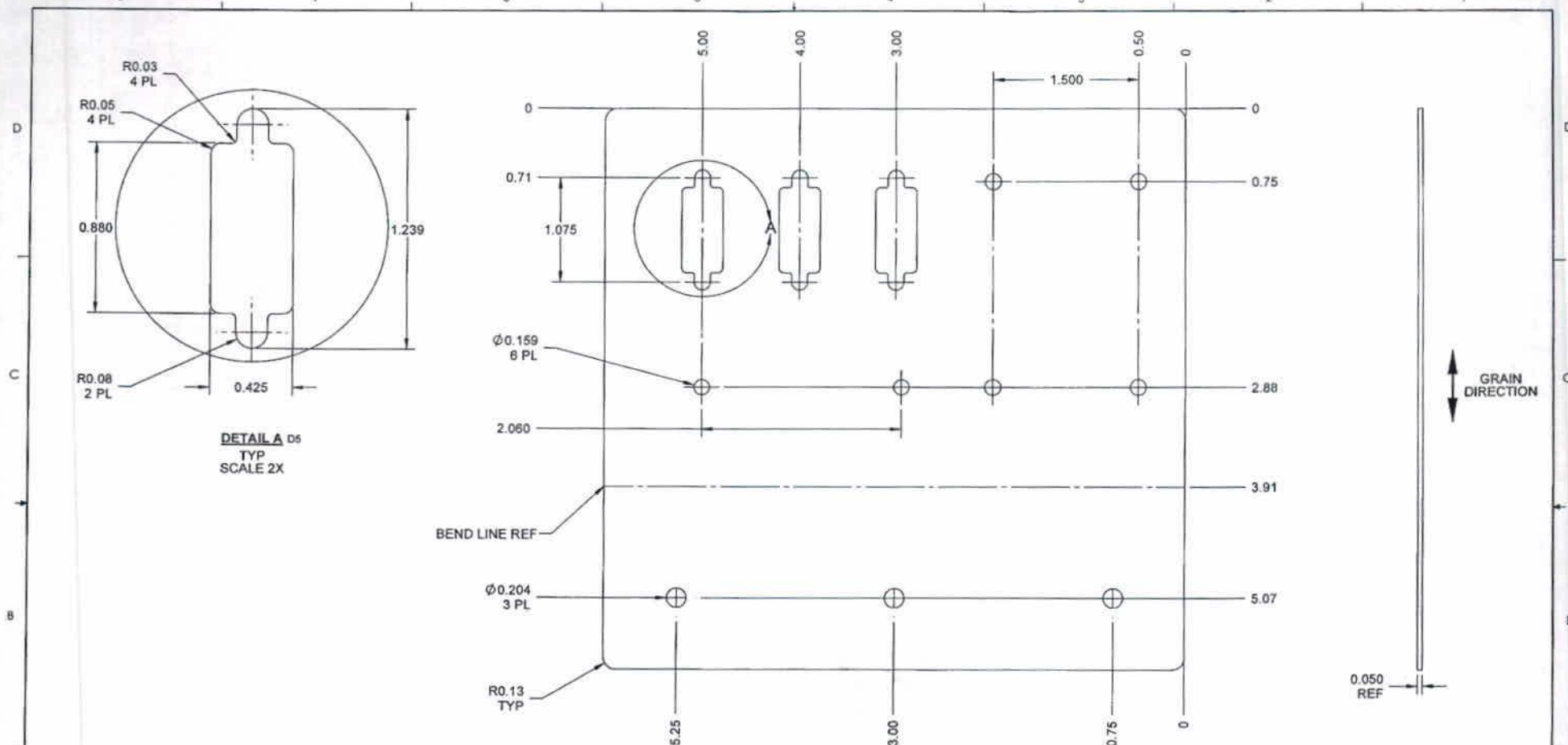
- NOTES:**
- 1) MATERIAL: MADE FROM D3897-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3897-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.16 lbs

RELEASED
09/06/09

A	NEW ISSUE		09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3897	SHEET 1 OF 2
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DETAIL A D5
TYP
SCALE 2X

D3897-1F ANGLE FLAT PATTERN

NOTES:

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REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

RELEASED
2/10/01 NW

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
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APPROVED	AS	TITLE	SCALE
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